



Date: Tuesday, 3/11/2008 1:17:13 PM
User: Kim Johnston

Process Sheet



| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARSHOE |
| Job Number : 37810 | |
| Estimate Number : 12736 | |
| P.O. Number : | Part Number : D353515 |
| This Issue : 3/11/2008 S.O. No. : | Drawing Number : D3535 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 36653 | Material : |
| Written By : | Due Date : 3/28/2008 Qty: 12 Um: Each |
| Checked & Approved By : <u>08 03 11</u> | |
| Comment : Est Rev:A New Issue 07-02-15 JLM | |
| Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC | |

Additional Product

Job Number: 



| Seq. #: | Machine Or Operation: | Description : |
|---------|---|---|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
| |  |  |

Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: 106748 HB 8-3-17



| | | |
|-----|---|---|
| 2.0 | WATER JET | FLOW WATER JET |
| |  |  |

Comment: FLOW WATER JET
1-Cut as per Dwg D3535
Dwg Rev: B HB 8-3-17
Prog Rev: B
2-Deburr if necessary HB 8-3-17

(12)



| | | |
|-----|---|---|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|---|---|
| 4.0 | QC8 | SECOND CHECK |
| |  |  |

Comment: SECOND CHECK

08/03/18 (12)

| | | |
|-----|---|---|
| 5.0 | BRAKE NC | NC BRAKE |
| |  |  |

Comment: NC BRAKE
1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-15

08/03/18

(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37810

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/18 (X12)

7.0

POWDER COATING

POWDER COATING



M 106442



(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/03/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18 (X12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 17

910

08-03-18 (X12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/18

Job Completion



mc 2008/3/18

(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|-------------------------------------|--|---------------------|-----------------|
| DART AEROSPACE LTD | | Work Order: | 37810 |
| Description: Wearshoe | | Part Number: | D3535-15 |
| Inspection Dwg: D3535 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.885 | +/-0.010 | 1.885 | * | | | |
| 2.000 | +/-0.010 | 2.000 | * | | | |
| 5.650 | +/-0.010 | 5.650 | * | | | |
| 9.150 | +/-0.010 | 9.150 | * | | | |
| 14.400 | +/-0.010 | 14.400 | * | | | |
| 19.650 | +/-0.010 | 19.650 | * | | | |
| 24.900 | +/-0.010 | 24.900 | * | | | |
| 30.150 | +/-0.010 | 30.150 | * | | | |
| 33.650 | +/-0.010 | 33.650 | * | | | |
| 35.650 | +/-0.010 | 35.650 | * | | | |
| 39.150 | +/-0.010 | 39.150 | * | | | |
| Ø0.188 | +0.005/-0.001 | .192 | * | | | |
| 24.00 | +/-0.030 | 24.00 | * | | | |
| 16.00 | +/-0.030 | 16.00 | * | | | |
| 8.00 | +/-0.030 | 8.00 | * | | | |
| 5.00 | +/-0.030 | 5.00 | * | | | |
| 0.300 | +/-0.010 | .304 | * | | | |
| 0.300 | +/-0.010 | .304 | * | | | |
| 0.038 | +/-0.010 | .034 | * | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|---------------------|---------------|--------------------|--------------------|----------------------------|------------|
| Measured by: | IB | Audited by: | [Signature] | Prototype Approval: | N/A |
| Date: | 8-3-17 | Date: | 08/03/18 | Date: | N/A |

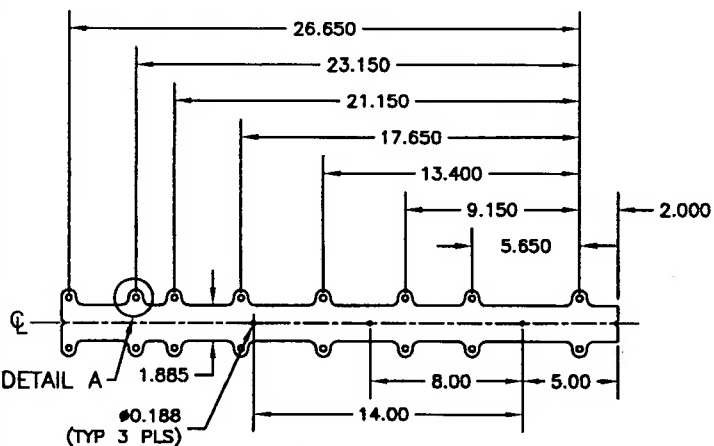
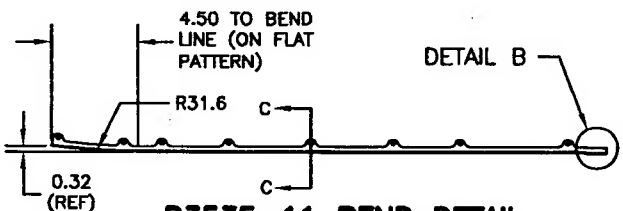
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 07.05.10 | New Issue | KJ/JLM | [Signature] |

DART

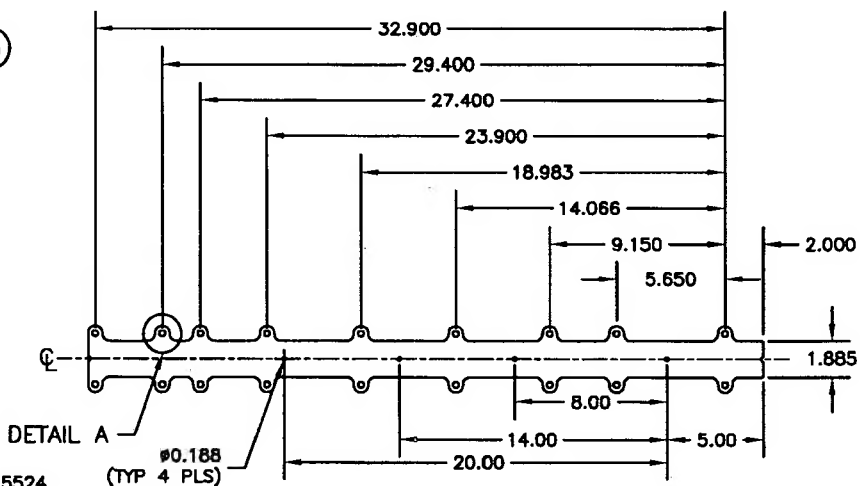
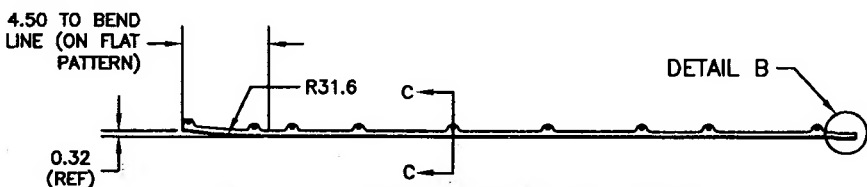
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07.04.24

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | REV. B |
|----------|----------|---------------------------------|--------------|
| CB | PH | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 7 |
| TH | TH | D3535 | |
| DATE | | TITLE | SCALE |
| 07.04.17 | | WEARSHOE | 1:10 |
| A | 06.10.25 | NEW ISSUE | |
| B | 07.04.17 | MOVE TAB OUTBOARD, ADD AMS SPEC | |

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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NO. 37870

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

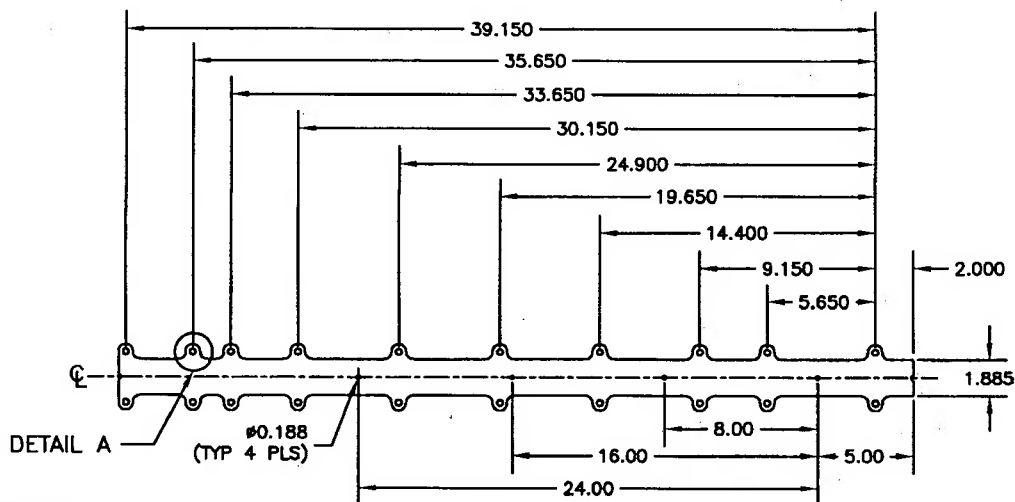
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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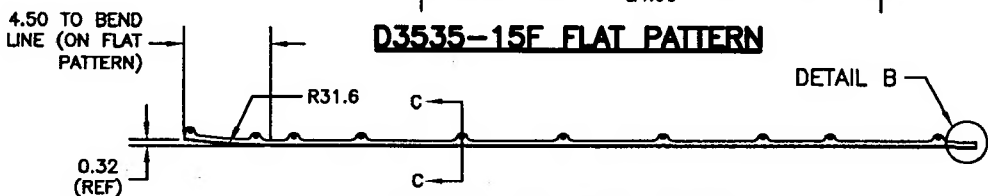
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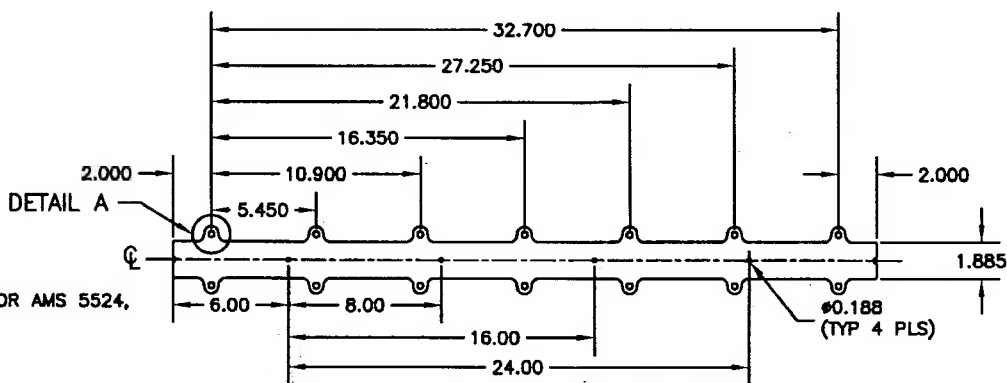
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|----------|----------|--------------------------|--------------|
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| DATE | DATE | TITLE | SCALE |
| 07.04.17 | | WEARSHOE | 1:10 |



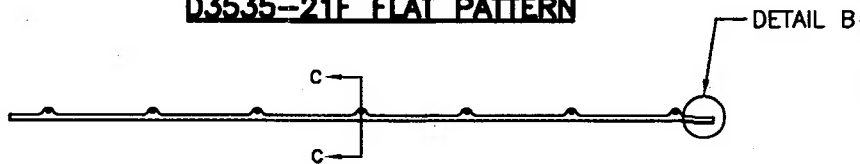
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

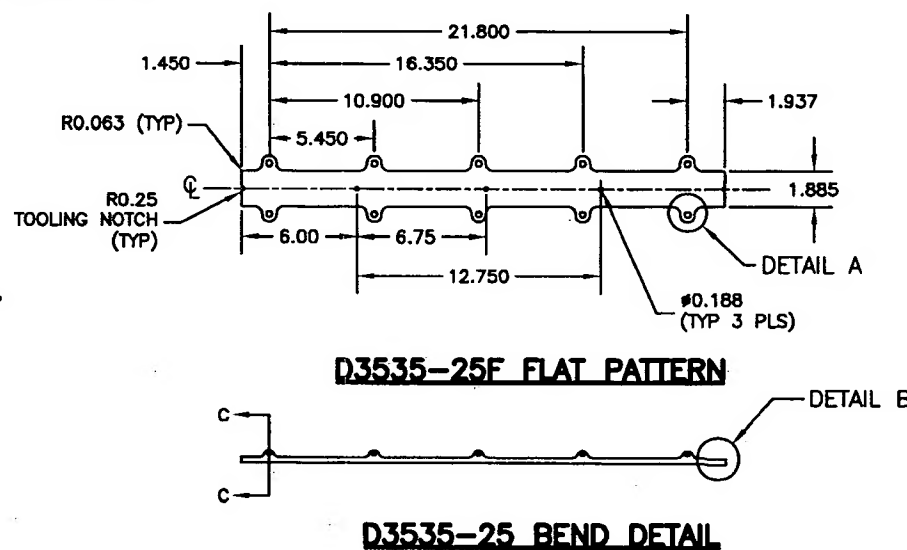
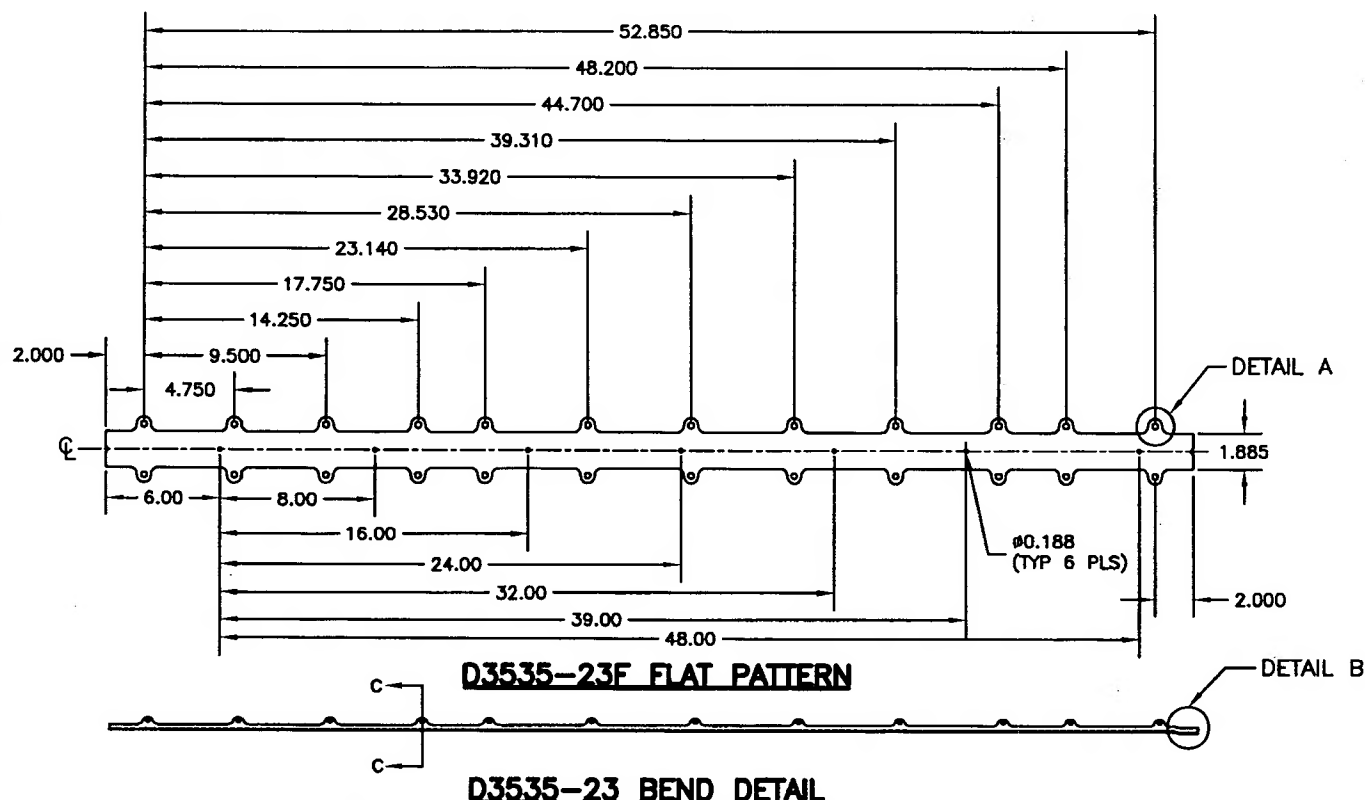
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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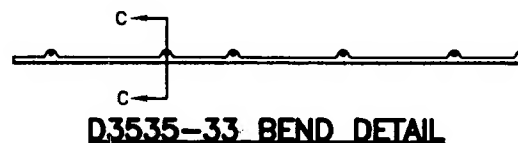
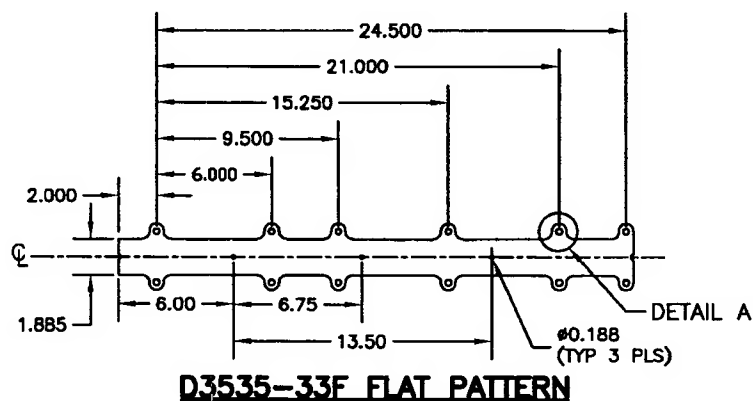
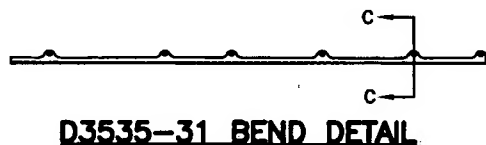
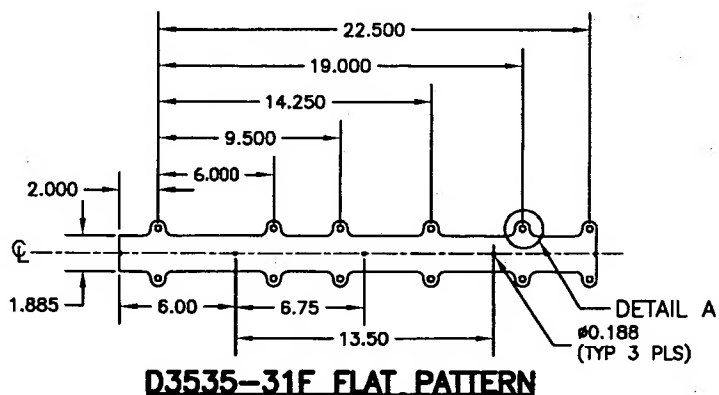
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| # | # | D3535 | |
| DATE | TITLE | WEARSHOE | SCALE |
| 07.04.17 | | | 1:10 |

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| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. D3535 |
| DATE | 07.04.17 | TITLE | WEARSHOE | REV. B SHEET 4 OF 7 |
| | | SCALE | 1:10 | |



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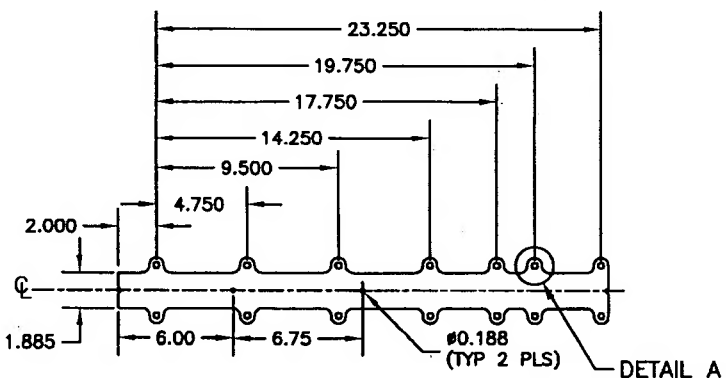
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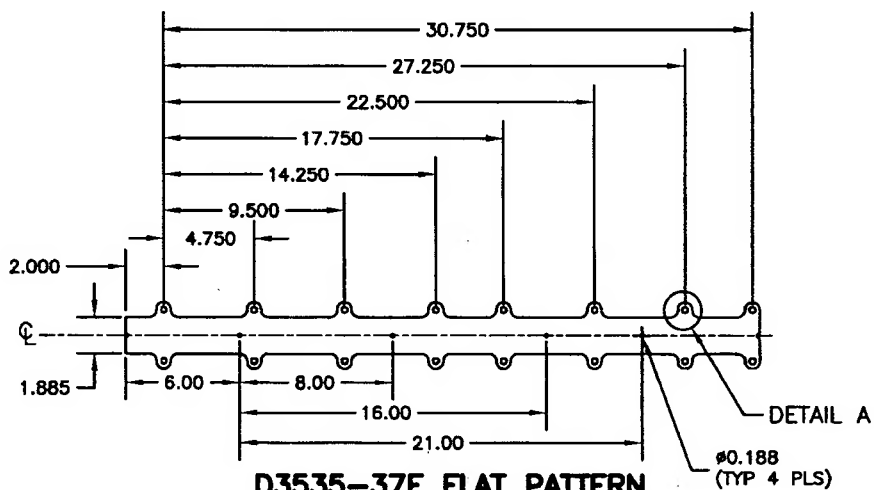
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| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 07.04.17 | DRAWING NO. | D3535 | REV. B |
| TITLE | WEARSHOE | SHEET | 5 OF 7 | SCALE |



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

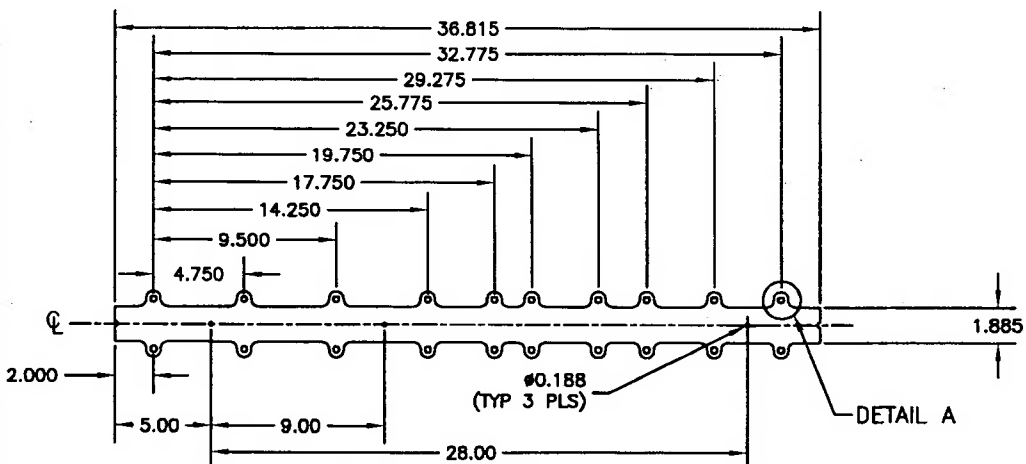
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- 3) PART IS SYMMETRICAL ABOUT C
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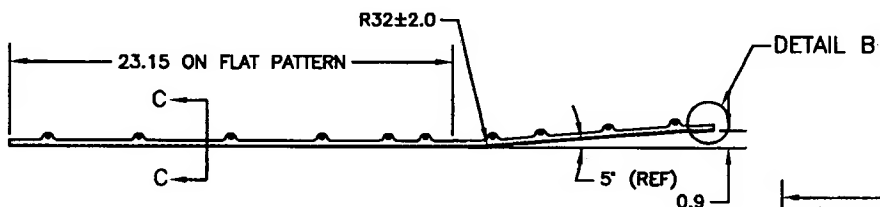
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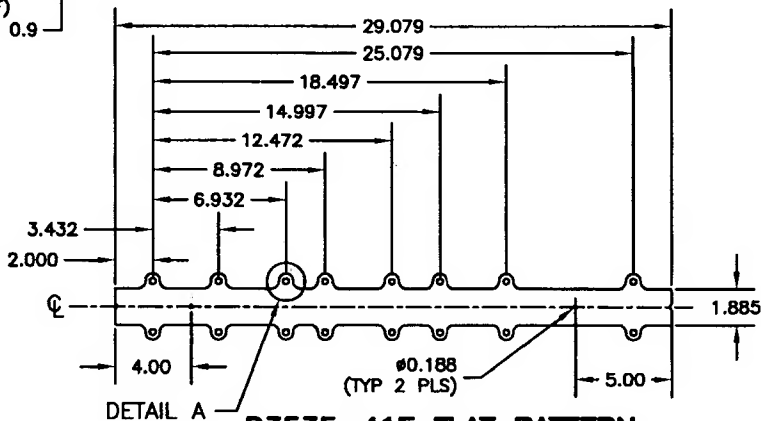
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| DATE | 07.04.17 | DRAWING NO. | D3535 | REV. B |
| | | TITLE | WEARSHOE | SHEET 6 OF 7 |
| | | | | SCALE 1:10 |



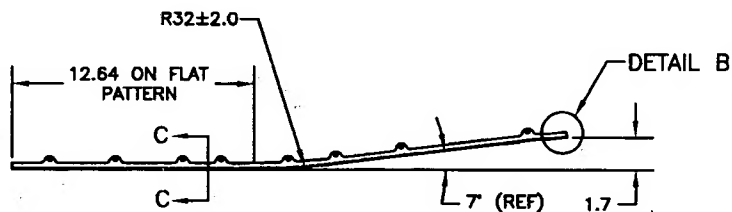
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN





D3535-41 BEND DETAIL

NOTES

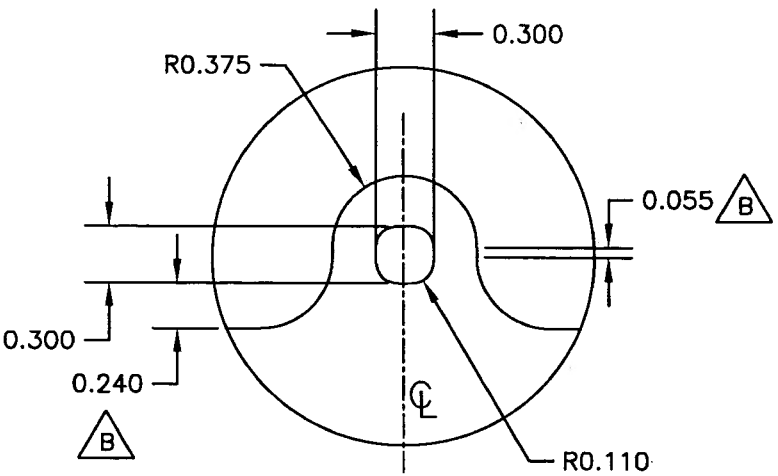
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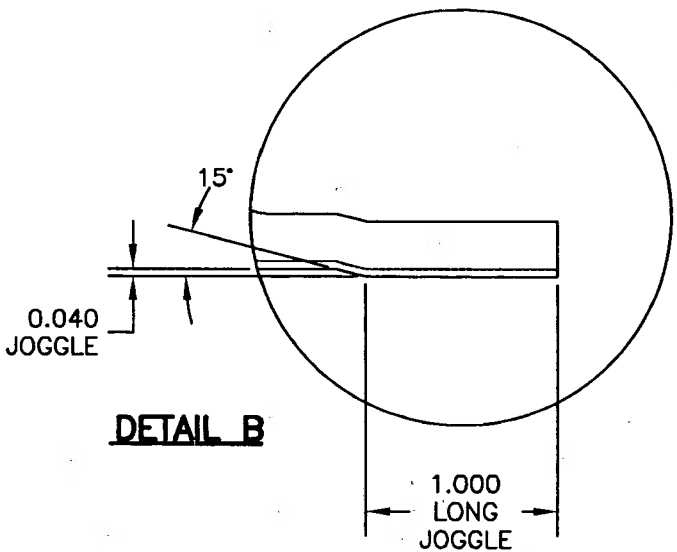
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|  |  | D3535 | SHEET 7 OF 7 |
| DATE | TITLE | | SCALE |
| 07.04.17 | WEARSHOE | | 1:1 |

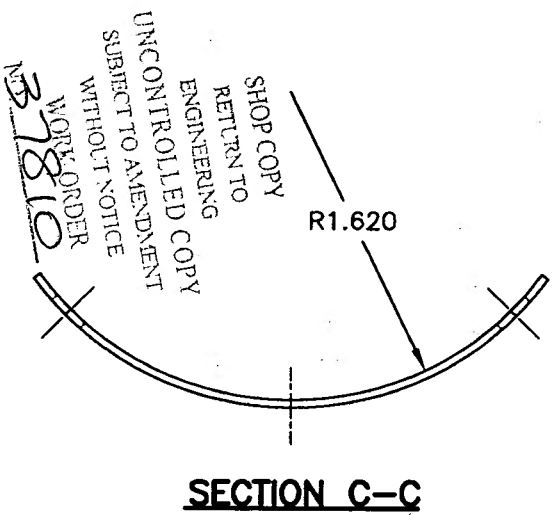
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DETAIL A



DETAIL B



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